

# Work Order ID 50391

July 13, 2009 12:54:44 PM



Page 1

Item ID: D3159-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 8.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 8.00



Customer:

## Reference:

Approvals: Process Plan:

*MR*

Date: 07-08-12 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
D3159	Rev C								
Shear	SHEAR	0.00							
Shear	Memo	0.00							
	Blank size: 1.700" x 1.545" x .063" thick. Grain along 1.545"								
110		0.00							
HAAS 1	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS CNC vertical machine #1	Memo	0.00							
	Machine as per Folio FA237U Stack of 7								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

*LB 9-8-11*

*LB 9-8-11*

*LB 9-8-11*

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Cust Item ID:

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Customer:

## Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Draw  
Number

2) S09/08/13

Draw  
Rev.

Plan  
Code

Accept  
Qty

counter  
44

Reject  
Qty

F

Reject  
Number

Insp.  
Stamp

140



Small Fab

Small Fab

0.00

0.00

Small Fab

Memo

1-Deburr break all sharp edges .005 to 0.010 12-C'sink holes as per Dwg D3159

150



Brake NC

NC BRAKE

0.00

0.00

Brake NC

Memo

Form as per drawing

QC5  
7/13/09



S09/08/13

counter  
44

F

Deburr m-h oal 08/11  
 ~~sink hole~~ m-h 09/08/13 (44X) (44X)

44 R

8809/08/13

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Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 8.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

Memo

0.00

JL 04-08-13

44X

170



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Assemble as per dwg.

  
08/08/13 44

180



QC

QC5- Inspect part completeness to step on W/O

0.00

→ Sorkulit

Quality Control

Memo

0.00

conten  
44X

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Setup Start



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Stop



Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 8.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 8.00



Customer:

## Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

190



Packaging

Packaging

Identify as per dwg & Stock Location *68*

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

*9/8/17*

*44x SP*

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

*09/08/25 JJ*

Memo

0.00

*MF 09-08-24*

# Picklist Print

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Work Order ID: 50391



Parent Item: D3159-041RevC



Parent Item Name: Bracket Assembly

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		170	sf	135.5726	0.1566	44		

6061-T6 .063 Sheet

## Warehouse

### Location

#### Main Warehouse

MAT 135.5726316

109463 1

110551 134.572632

109463

B 9-8-11

100 Each 8,433.000 16.0000



MS20426AD3-13

Purchased

No

## Warehouse

### Location

#### Main Warehouse

ST 8433

104374 4433

110398 4000

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

MS21059L06

Purchased

No

170 Each 8.0000 8.0000



Nutplate

## Warehouse

### Location

#### Main Warehouse

ST 8

13131 8

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

M112255

(88a)

44A

M7681

RIVET

✓

✓ 09/08/13

44

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	SD391
<b>Description:</b>	<b>BRACKET ASSEMBLY</b>	<b>Part Number:</b> D3159-041
Inspection Dwg: D3159-1	Rev: C	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

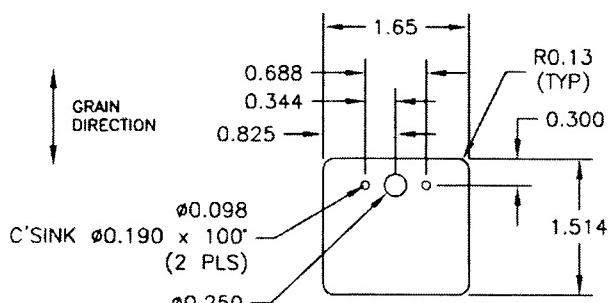
## **x First Article**      **Prototype**

Measured by:	FB	Audited by:	S	Prototype Approval:	A
Date:	9-8-11	Date:	09/05/12	Date:	A

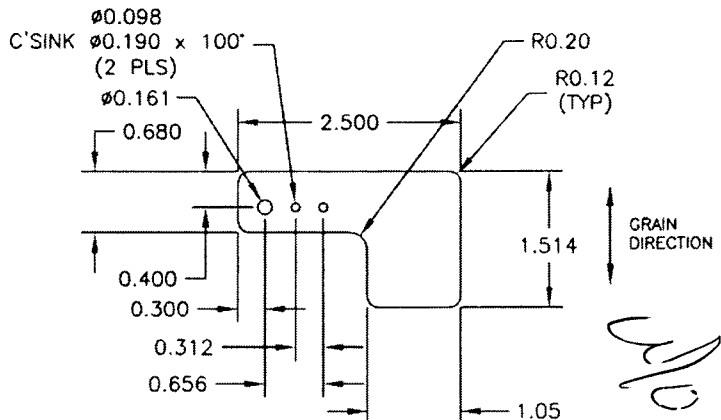
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	..	New Issue	KJ/JLM	

**DART**

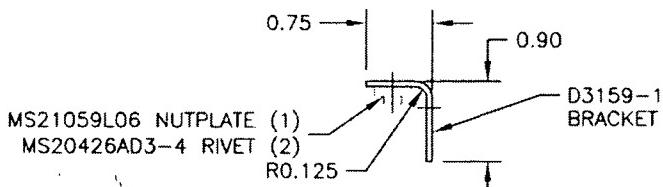
DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3159	REV. C SHEET 1 OF 1
DATE 05.11.21		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	
C	05.11.21	CORRECT VIEW	



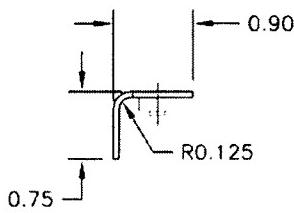
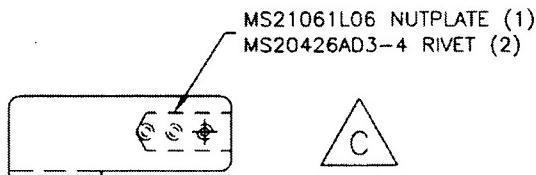
D3159-1F FLAT PATTERN  
(USED TO MAKE D3159-1 BRACKET)



D3159-3F FLAT PATTERN  
(USED TO MAKE D3159-3/-4 BRACKETS)



D3159-041 BRACKET ASSEMBLY



D3159-043 BRACKET ASSEMBLY (SHOWN)  
REPLACES PREMIER P/N B30-23000-259  
(D3159-044 BRACKET ASSEMBLY (OPPOSITE).  
REPLACES PREMIER P/N B30-23000-260)

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY D3159-041/-043/-044 WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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